

**\*97855\***

March-01-13 8:48:53 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 3/01/13      **Start Qty:** 20.00

**\*20\***

**Required Date:** 3/22/13      **Req'd Qty:** 20.00

**\*20\***

**Reference:**

Run Start \*NR1\*

Approvals: Process Plan: MLS Date: 13-03-01 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

[illegible]

# Work Order ID 97855

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Item ID: D2171 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Clamp  
Start Date: 3/01/13 Start Qty: 20.00 **\*20\*** Cust Item ID:  
Required Date: 3/22/13 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				<u>20</u>	<u>13-03-06</u>	<u>DAS</u> <u>09</u> <u>8-89</u>	
130 <b>*130*</b> Brake NC Brake NC	Form as per dwg Small Fab  Memo 1- remove press and machine marking as necessary	0.00  0.00				<u>20</u>		<u>Sf</u> <u>13/03/12</u>	
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		<u>DAS</u> <u>21</u> <u>9-8</u>		<u>20</u>			<u>13.3.13</u>

# Work Order ID 97855

**\*97855\***

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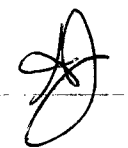
March-01-13 8:48:53 AM


Item ID: D2171 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Clamp  
 Start Date: 3/01/13 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 3/22/13 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>ST 456</u>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

20x \_\_\_\_\_ SP13-3-13.

13/3/14 

 13-05-13

# Picklist Print

March-01-13 8:48:52 AM

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Work Order ID: 97855

Parent Item: D2171

Parent Item Name: Clamp

Start Date: 3/01/13

Required Date: 3/22/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 11.04.26 now made in house DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	589.6560	0.0258	0.5431579		3/13/13	

Location

Loc Qty

Loc Code

MAT020

589.656

122245

5.156

123136

140.8

124428

123.7

124572

320

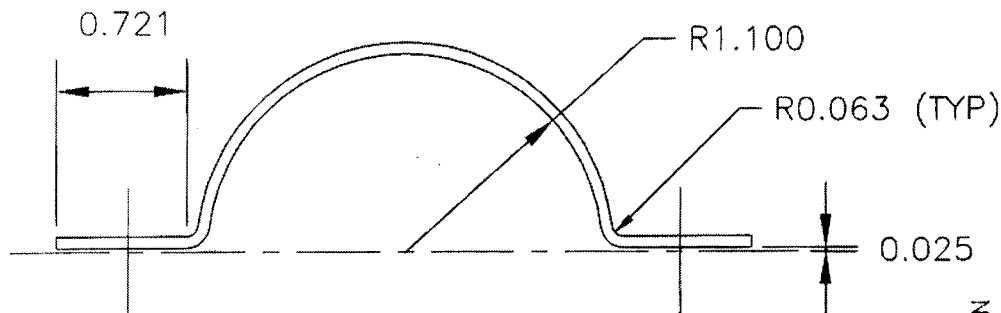
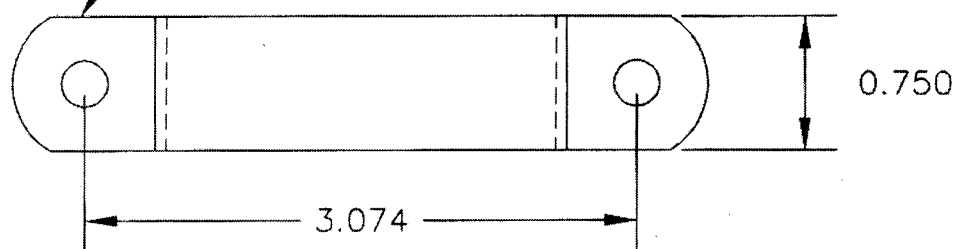




DESIGN Bw	DRAWN BY <del>DA</del>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2171	REV. D SHEET 1 OF 1
DATE 99.03.08		TITLE CLAMP	SCALE 1:1
B	96.01.29	REDRAWN	
C	97.05.14	RADIUS CHANGED, CUSHION ADDED	
D	99.03.08	REMOVE CUSHION (TSR A890) 4.158 WAS 4.888	

99.03.11 KE

PUNCH ENDS PER SPEC  
CONTROL DRAWING D2727



MATERIAL: 304/316 SS 0.063 THICK  
FLAT LENGTH: 4.968 END-END  
4.158 HOLE-HOLE



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WORK ORDER NO. 97855 MCB  
13-03-01